

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009520**Date Inspected:** 12-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Xian Ping		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	OBG & TOWER Components	

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

**BAY 1**

This QA Inspector observed the following work in progress:

SMAW process tack welding of weld joint # 007 located on Counter Weight CW001B – PP048. Welder is identified as 214453. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

SMAW process tack welding of weld joint # 005 located on Counter Weight CW001B – PP048. Welder is identified as 214453. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

**BAY 2**

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## WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

SMAW process tack welding of weld joint # 106 located on Floor Beam FB3054 – 001. Welder is identified as 045251. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

FCAW process welding of weld joint # 032 located on Floor Beam FB3010 – 001. Welder is identified as 062438.

ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

SMAW process tack welding of weld joint # 041 located on Floor Beam FB3056 – 001. Welder is identified as 049972. ZPMC QC is identified as Zhang Hai Feng. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 – FCM.

### BAY 5

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint # 010 located on Traveler Rail 10TR3 – 019. Welder is identified as 068858.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 012 located on Bike Path BK001 – 037. Welder is identified as 204342.

ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

FCAW process welding of weld joint # 014 located on Traveler Rail 10TR3 – 019. Welder is identified as 068858.

ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

FCAW process welding of weld joint # 012 located on Bike Path BK001 – 039. Welder is identified as 215009.

ZPMC QC is identified as Wang Liyang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

### BAY 6

### Tower

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #8B located on Tower Strut WD1 – A305 – 53M – 3. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply

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with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

SMAW process welding of weld joint #8A located on Tower Strut WD1 – A305 – 53M – 1. Welder is identified as 067707. ZPMC QC is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – FCM – Repair – 1.

Cross Beam – 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #005 located on Cross Beam CB202A – 008. Welder is identified as 058174. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

FCAW process welding of weld joint #017 located on Cross Beam CB202A – 008. Welder is identified as 053609. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
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